



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3049-1
Job Sheet 170092



Part No: D3049-1

Job Qty: 10 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/10/18

Job Tracking No:

Due Date: 1/23/18

Created By: Linda Lacelle

Type: Stock

Description:

Customer: Heliswiss Iberica SA (CHELI02)

Hangar 4, Lado Norte, Aeropuerto De Sabadell, Barcelona Sabadell, , 08205 Spain ph:011 34 93 720 6090
fx:34-937-100130.

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/22/18	1/22/18	0.00	0.00	Start Up Waterjet		DL 18/01/18
110	Waterjet	10 pcs	1/22/18	1/22/18	0.00	2.99	Waterjet1		DL 18/01/19
120	CNC Vertical Machining	10 pcs	1/23/18	1/23/18	0.21	12.20	HAAS1-3		SL 18/01/20
130	QC	10 pcs	1/23/18	1/23/18	0.00	0.00	QC2 Machining-1		SL 18/01/20
140	QC	10 pcs	1/23/18	1/23/18	0.00	0.00	QC8 Machining-1		SL 18/01/21
170	Packaging	10 pcs	1/23/18	1/23/18	0.00	0.00	Packaging3		DAS
180	QC21-SA	10 Ea	1/23/18	1/23/18	0.00	0.00	QC21		21 JAN 23 2018

Part Op 110 - CUT BLANK AS PER FILE D3049-1_BLANK

Descriptions: 120 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA165 and Dwg D3049Identify as D3049-1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MUHMWB10	34	836	0	0

DART
AEROSPACE
S031092



Bearpaw

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO:
Revision:
Operation:
Change No:

D3049 - 1

Start up Operation

Mfg Date: 01/10/18
Job No: 170092

Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type Special Comments
1	Bearpaw	0.260Inches + 0.005 - 0.000	0.265 0.260	Diameter
2	Bearpaw	0.930Inches ± 0.030	0.960 0.900	
3	Bearpaw	0.400Inches + 0.030 - 0.000	0.430 0.400	
4	Bearpaw	2.000Inches ± 0.030	2.030 1.970	
5	Bearpaw	10.310Inches ± 0.010	10.320 10.300	
6	Bearpaw	2.870Inches ± 0.030	2.900 2.840	
7	Bearpaw	8.000Inches ± 0.030	8.030 7.970	
8	Bearpaw	0.380Inches ± 0.030	0.410 0.350	
9	Bearpaw	11.500Inches ± 0.030	11.530 11.470	
10	Bearpaw	0.070Inches ± 0.030	0.100 0.040	
11	Bearpaw	45.000Degrees ± 0.500	45.500 44.500	Angle
12	Bearpaw	0.440Inches + 0.030 - 0.000	0.470 0.440	
13	Bearpaw	0.250Inches ± 0.030	0.280 0.220	Radius
14	Bearpaw	0.950Inches + 0.030 - 0.010	0.980 0.940	
15	Bearpaw	0.690Inches ± 0.030	0.720 0.660	
16	Bearpaw	0.200Inches ± 0.030	0.230 0.170	
17	Bearpaw	0.250Inches ± 0.030	0.280 0.220	Radius
18	Bearpaw	0.250Inches ± 0.030	0.280 0.220	
19	Bearpaw	45.000Degrees ± 0.030	45.030 44.970	Angle

Plex 1/10/18 7:29 AM dart.lacelle.linda

DART AEROSPACE LTD		Work Order:	
Description: Bearpaw		Part Number:	D3049-1
Inspection Dwg: D3049 Rev: B		Page 1 of 1	

INSPECTION SHEET

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A Ø0.260	+0.005/-0.000	Ø0.260	✓		G.P	
B 0.93	+/-0.030	0.93	✓		Ver	ED-6
C 0.40	+0.030/-0.000	0.410	✓		Ver	"
D 2.00	+/-0.030	2.000	✓		Ver	"
E 10.31	+/-0.010	10.31	✓		TAPE	
F 2.87	+/-0.030	2.87	✓		Ver	"
G 8.00	+/-0.030	8.000	✓		TAPE	
H 0.38	+/-0.030	0.380	✓		Ver	"
I 11.50	+/-0.030	11.50	✓		TAPE	
J 0.07 x 45°	+0.030/-0.010	0.068 x 45°	✓		Ver	"
K 0.44 - 0.47	+/-0.000	0.455	✓		Ver	"
L R0.25	+/-0.030	0.25	✓		R.G.	
M						
N 0.95	+0.030/-0.010	0.950	✓		Ver	ED-6
O 0.69	+/-0.030	0.700	✓		"	"
P 0.20	+/-0.030	0.190	✓		D.G.	
Q R0.25	+/-0.030	0.25	✓		R.G.	
R 0.25 x 45°	+/-0.030	0.25 x 45°	✓		Ver	"
S						
T						
U						
V						
W						
X						
Y						
Z						
AA						
AB						

Measured by: S.C.	Checked by: [Signature]	QC Inspector:
Date: 18/01/20	Date: 18/01/22	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD	
C	16.10.20	Dwg Rev updated	KJ	